

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006834**Date Inspected:** 19-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG crossbeams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**OBG cross beam CB1**

This QA observed that the contractor has moved this Cross Beam (CB) to the trial assembly yard. This QA observed ZPMC personnel covering the interior painted surfaces with plastic tarps. No other significant work was observed on this CB during the time this QA was present.

**OBG cross beam CB2 (in superstructure trial assembly)**

This QA observed ZPMC personnel match drilling bolt holes on the top and side panels at the splice joints to the east and west lines using the splice plates as a template. This QA observed that the contractor appeared to be drilling the holes larger than what is specified on the shop drawings. Drawing X201 specifies that the holes be drilled 27mm for a 24mm bolt. The contractor is drilling the holes 30mm. This QA informed ZPMC QC identified as Mr. Shen Xuejun and ABF inspector identified as Mr. Larry Lu of this issue. Mr. Lu informed this QA that RFI #ABF-RFI-000732R00 allows the contractor to drill the holes to 30mm at the splice joints on crossbeams CB1, CB2 and CB3. Mr. Lu presented an approved copy of this RFI to this QA for review.

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### OBG cross beam CB3 (in superstructure trial assembly)

This QA observed ZPMC personnel match drilling bolt holes on the top and side panels at the splice joints to the east and west lines using the splice plates as a template. This QA observed that the contractors welding personnel have temporarily tack welded fit up lugs that are not specified on the shop drawings to SPCM material. The lugs appear to be for the purpose of aiding in the positioning of the splice plates between the crossbeams and the OBG segments. Tack welding outside of the designated weld joints on SPCMs' is prohibited by AWS D1.5 2002 section 12.13.1.1 and the special provisions section 10-1.59. This QA informed ZPMC QC identified as Mr. Shen Xuejun and ABF QC identified as Mr. Noe Pasiola that an incident report would be generated for this non-compliance. See attached photos.

### OBG cross beam CB4

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

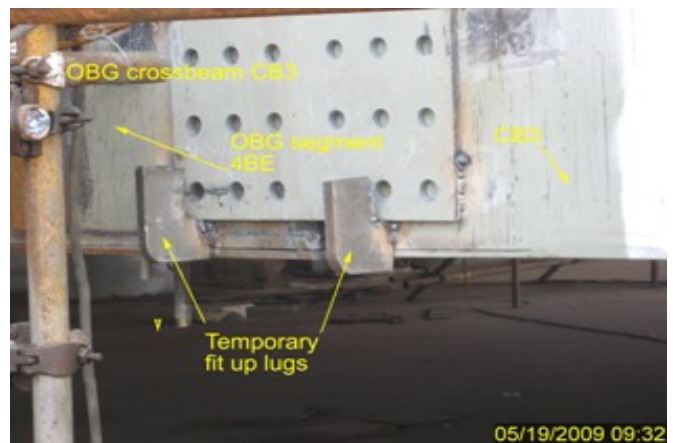
### OBG cross beam CB5

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

### OBG cross beam CB6

This QA observed the contractors personnel tack welding temporary bracing inside this crossbeam. No other significant work was observed on this crossbeam during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

As mentioned above.

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Prue,Erik	QA Reviewer

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